

AMENDMENTS TO THE CLAIMS:

Please amend the claims as follows:

1. (Currently Amended) A stamping process in which a metal sheet [[T]] is stamped between a bottom die [[10]] and a punching die [[4]] clamped by a first blank holder front (AV) and a second blank holder rear (AR) blank holders, characterized in that the second blank holder AR 20 ~~is widened toward the rear relative to the dimensions of the prior art and, at an~~ the end adjacent to the punching die [[4]] which is ~~(that is, the a front (AV) end of the second rear (AR) blank holder),~~ has a convex form; ~~that is, a form which permits progressive deformation of the metal sheet in depth and over a greater blank holder length, and is not a in place of the right angle blank holder of blank holders of the prior art.~~

2. (Currently Amended) A stamping process in which a metal sheet [[T]] is stamped between a bottom die [[10]] and a punching die [[4]] clamped by a first blank holder and a second blank holder front (AV) and rear (AR) blank holders, wherein the rear second blank holder (AR) 20 ~~is widened toward the rear and is geometrically adapted to a the level of an~~ the area [[14]] adjacent to the punching die [[4]] in order to reproduce a portion of the ~~at least one part of the~~ form created by the punching die [[4]] in its AV part, wherein said portion can be ~~or to reproduce~~ precisely one-half, or more than one-half, up to the entirety of the form created by the punching die [[4]].

3. (Currently Amended) The stamping process as specified in claim 1, wherein the first blank holder also has a convex form ~~front blank holder (AV) 30 is also widened (toward the front).~~

4. (Currently Amended) The stamping process as specified in claim 1, wherein a the geometric adaptation of the second blank holder AR represents one-half the form created by the punching die 4 in its AV part.

5. (Currently Amended) The stamping process as specified in claim 1 adapted for manufacture of multiple-seat benches that have , ~~in particular ones with two to six or eight seats or more, requiring several consecutive seat forms or imprints 11, 12 separated by interval i, wherein use is made of a tool the~~ second AR blank holder [[100]] of which reproduces (in its part B) at least one portion that can be part, ~~preferably precisely one-half (A) of the seat form 11, 12 created by the punching die 120 in its AV part, or~~ optionally ~~creates~~ more than one-half, up to the totality, of the form created by the punching die.

6. (Currently Amended) The stamping process as specified in claim 5 adapted for manufacture of multiple-seat benches that have , ~~in particular with six to eight or more seats, requiring a plurality of consecutive seat forms or imprints 11, 12 separated by an interval i, wherein the~~ second blank holder AR ~~100~~ and the punching die [[120]] are in an area the geometry of which is adapted for reproduction of the desired form of the interval i defined as mandatorily present between two consecutive seat forms.

7. (Currently Amended) The stamping process as specified in claim 5 adapted for manufacture of multiple-seat benches that have , ~~in particular ones with two to six or eight or more seats, requiring a plurality of consecutive seat forms or~~

imprints ~~[[11, 12]]~~ separated by an interval i , ~~wherein the blank holder has been widened toward the front.~~

8. (Currently Amended) The stamping process as specified in claim 5, adapted for manufacture of multiple-seat benches that have, ~~in particular ones with two~~ to six or eight or more seats, requiring a plurality of consecutive seat forms or imprints ~~11, 12~~ separated by an interval i , wherein the profile ~~[[8]]~~ of the first blank holder AV ~~110~~ remains is horizontal.

9. (Currently Amended) The stamping process as specified in claim 5, wherein the first blank holder ~~[[110]]~~ has ~~may have~~ a slightly convex surface or profile favoring transition in deformation from the metal sheet to the punching die.

10. (Currently Amended) The stamping process as specified in claim 1, wherein the metal sheet ~~[[T]]~~ is positioned so as to produce a first stamping form or initial stamping and "initial stamping," then the metal sheet which has undergone this first stamping or initial stamping is then displaced toward the rear and the initial stamping is brought to rest in ~~area 130 AV of the~~ second blank holder AV ~~of the blank holder AR 100~~, after which a ~~the~~ second stamping is repeatedly carried out ~~and so forth~~ until 2, 3, 4, 5, 6, 7, or 8 imprints or more have been produced.

11. (Currently Amended) The stamping process as specified in claim 1, wherein the second blank holder ~~AR 100~~ reproduces in a ~~its~~ part B one-half of the seat imprint, which is identical to a half-form ~~A of part AV~~ of the punching die ~~[[120]]~~, an ~~the~~ arrow indicating the direction of step-by-step movement of the metal sheet to permit production of consecutive imprints.

12. (Currently Amended) The stamping process as specified in claim 1, wherein the tool comprises, between the second blank holder AR-100 and the punching die [[120]], a shoulder [[150]] which reproduces the interval i which must be present between two consecutive seat imprints.

13. (Currently Amended) The stamping process as specified in claim 1, wherein a pressure of ~~the order of~~ 150 to 300 or 350 ~~to~~ is applied for a metal sheet of 15/10 mm or of 12/10 mm or of 10/10, 8/10, or 6/10 mm.

14. (Currently Amended) The stamping process as specified in claim 1, wherein this shoulder [[150]] forming interval i is reduced to values of ~~the order of~~ 1 to 3 or 5 cm for 15/10 mm metal sheets, or ~~even one~~ measuring 10/10 or 8/10 or 6/10 mm, or ~~even preferably~~ to a value $i = 0$, without marking and without folds or curls.

15. (Currently Amended) The stamping process as specified in claim 1, wherein at least one part of base part B of blank holder AR [[100]] is replaced with other support means or by ~~such as~~ friction rollers, etc.

16. (Currently Amended) The stamping process as specified in claim 1, wherein the stamping process comprises a metal sheet performing step, ~~preferably performing~~ by means of a folding machine.

17. (Currently Amended) The stamping process as specified in claim 16, wherein the metal sheet is preformed along line a, b, c, rounded part d, e, f, with all sections being straight except curved section d, or the preform is made up of sections a, h (straight), d, e, f, or the preform is made up of sections a, h (straight), d, g (straight).

18. (Currently Amended) The stamping process as specified in claim 1, wherein the metal sheet [[T]] is positioned without concern for vertical alignment with the punching die [[4]] and the punching die [[10]], and it being possible for the metal sheet is to be offset, ~~for example,~~ by distance m relative to the vertical alignment, and wherein the press is then lowered slowly and the metal sheet is allowed to center itself on the tool.

19. (Currently Amended) A tool for application of the stamping process as specified in claim 1, characterized in that such tool comprises a bottom die [[10]] and a punching die [[4]] clamped by first and second front (AV) and rear (AR) blank holders, and in that the blank holder AR [[20]] is widened toward the rear ~~in comparison to the dimensions of the prior art~~ and has on an the end adjacent to the punching die [[4]] that is ~~(that is, the front end of the rear extremity)~~ extremity, a convex shape that is, ~~that is,~~ a shape which permits progressive deformation of the metal sheet in depth, and over a greater blank holder length in comparison to a ~~to the~~ right angle blank holder ~~of blank holders of the prior art.~~

20. (Currently Amended) The tool as specified in claim 19, wherein the rear second blank holder ~~(AR)-20~~ is widened toward a ~~the~~ rear and is geometrically adapted at ~~the~~ a level of area [[14]] adjacent to the punching die for reproduction of at least a portion ~~one part~~ of the form created by punching die 4 ~~in its AV part,~~ said portion optionally being ~~of~~ one-half or more than one-half, and up to the entirety of the form created by the punching die.

21. (Currently Amended) The tool as specified in claim 19, wherein the first blank holder ~~(AV)-30~~ is also ~~widened~~ wider toward a front ~~(toward the front)~~.

22. (Currently Amended) The tool as specified in claim 19, wherein geometric adaptation of the second blank holder ~~[[AR]]~~ reproduces in a ~~its~~ part B one-half A of the shape created by the punching die ~~in its part AV~~.

23. (Currently Amended) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches requiring a plurality of consecutive seat forms or imprints ~~[[11, 12]]~~, of ~~in particular~~ two to six or eight seats or more, separated by an interval i, wherein the second blank holder ~~AR-100~~ reproduces at least one portion, said portion optionally being part, preferably one-half the seat form produced by the punching die ~~120 in its AV part~~, or ~~reproduces~~ more than one-half, up to the entirety, of the form created by the punching die.

24. (Currently Amended) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches, requiring a plurality of consecutive seat forms or imprints ~~[[11, 12]]~~ separated by an interval i, of ~~in particular~~ two to six or eight seats or more, wherein there is between the second blank holder ~~[[AR]]~~ and the punching die ~~[[120]]~~ an area ~~[[150]]~~ the geometry of which is adapted for reproduction of the desired shape of the interval i ~~defined as~~ mandatorily present between two consecutive seat forms, i optionally equaling zero.

25. (Currently Amended) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches of ~~, in particular~~ two to six or eight or more

consecutive seat forms or imprints $[[11, 12]]$ separated by an interval i , wherein the first blank holder AV-440 has been wider ~~widened~~ toward the front.

26. (Currently Amended) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches of ~~, in particular~~ two to six or eight or more consecutive seat forms or imprints $[[11, 12]]$ separated by an interval i , wherein the tool comprises between the first blank holder AV-400 and the punching die $[[120]]$ a shoulder $[[150]]$ which reproduces the interval i which must be present between two consecutive seat imprints.

27. (Currently Amended) The tool as specified in claim 19, wherein, in order that the stamping pitch may be modified as desired, the tool is designed in two separate parts by a transverse cut (~~that is, one~~ perpendicular to the direction of advance of the metal sheet) at the level of the center of the punching die $[[4, 120]]$, this forming the base tool at minimum pitch, which parts ~~may be~~ separated from each other by a ~~the~~ desired pitch modification value $[[E]]$, and wherein the tool comprises one or more sets of four dismountable pieces called bottom die $[[460]]$, punching die $[[480]]$, and blank holder $[[490 \text{ and } 420]]$ shims adapted for insertion into space $[[E]]$ in an appropriate set.

28. (Currently Amended) The tool as specified in claim 27, wherein such tool is adapted for manufacture of multiple-seat benches of ~~, in particular for~~ two to six or eight seats or more, requiring a plurality of consecutive seat forms or imprints $[[11, 12]]$ separated by an interval i .

29. (Currently Amended) The tool as specified in claim 26, wherein such shims of bottom die [[460]], punching die [[48]], and blank holder [[49 and 20]] are may be fastened by a any mechanical means or by bolting ~~such as bolting, etc.~~

30. (Currently Amended) ~~Stamping presses~~ A stamping press equipped with a tool as specified in claim 19.

31. (Currently Amended) Stamped articles and products that , ~~in particular ones such as~~ include successive repetitive imprints, wherein ~~in particular whenever~~ the imprints are close together, or ~~even~~ adjacent ($i = 0$), and ~~in particular benches~~ with a plurality of seats of , ~~in particular six or more, in particular two to six or eight seats or more, characterized in that such stamped articles and products have been~~ manufactured by a process as specified in claim 1.

32. (Currently Amended) Stamped articles as specified in claim 31, wherein the ~~such~~ articles are made with metal sheets of a thickness of ~~various customary thicknesses, in particular 15/10, 12/10, or 10/10 mm, of a various common or~~ stainless steel ~~steels~~, optionally provided with a temporary, provisional, or definitive coating, or under a finishing layer, or again made of plates of plastics or composites of ~~any type~~.

33. (Currently Amended) A set of a ~~Sets of~~ bottom die [[460]], punching die [[480]], and blank holder [[490 and 420]] shims as specified in claim 27.